

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002072**Date Inspected:** 01-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China

<b>CWI Name:</b>	N/A			<b>CWI Present:</b>	Yes	No	
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006			<b>Component:</b>	OBG		

**Summary of Items Observed:**

UT-DP042-002

This Quality Assurance (QA) inspector arrived at ZPMC for observation of the SAS super structure fabrication and performed Ultrasonic Examination (UT) on the closed rib Partial Joint Penetration (PJP) weld joints. This Verification was performed after ZPMC performed there UT testing. It was noted that on weld DP042-002 there were multiple locations that had less than 9.6mm of Depth Of Penetration (DOP). The Deck Panel noted above is still process due to the QA verification performed noted multiple areas that had to be evaluated for one 800mm section which reduced the time frame aloud to perform the QA verification. Of this area after evaluation it was determined that the indications were acceptable due to the thickness material of the closed rib being a minimum of 12.7mm and a maximum of 13.5mm. This QA inspector will complete the UT verification tomorrow during his shift.

**Summary of Conversations:**

No conversations noted today.

**Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Pat Lowry, (858) 344-2712, who represents the Office of Structural Materials for your project.

**Inspected By:** Riley,Ken

Quality Assurance Inspector

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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**Reviewed By:** Hager,Craig

QA Reviewer